

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008843**Date Inspected:** 04-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	CWI: Liu Xiao Zhong /Li Ming			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower components		

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Repair welding of weld Joint# 1A/B located on PCMK ESD1 SPSA3-53. Welder is identified as 040723. ZPMC QC is identified as Liu Xiao Zhong . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G (2F) Repair.

Repair welding of weld Joint# 2 A/B located on PCMK WSD1 SPSA3-53. Welder is identified as 046706. ZPMC QC is identified as Liu Xiao Zhong . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G (2F) Repair.

Repair welding of weld Joint# 2 A/B located on PCMK ESD1 SPSA3-55. Welder is identified as 040759. ZPMC QC is identified as Liu Xiao Zhong . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2G (2F) Repair.

Welding of weld Joint# 1 located on PCMK ESTL3-4 K/K. Welder is identified as 068206. ZPMC QC is identified as Zhang Zhi Neng . The welding variables recorded by QC appeared to comply with the specified WPS

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no. B-T-2233-B-U2a-F.

Welding of weld Joint# 4 located on PCMK ESTL3-4 K/K. Welder is identified as 066471. ZPMC QC is identified as Zhang Zhi Neng . The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U2a-F.

SMAW Process:

Repair welding of weld Joint# 84 A/B located on PCMK ESTL3-4 B/K. Welder is identified as 040655. ZPMC QC is identified as Cao Cheng . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-4G (4F) Repair.

Repair welding of weld Joint# 84 A/B located on PCMK ESTL3-4 B/K. Welder is identified as 040675. ZPMC QC is identified as Cao Cheng . The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-SMAW-4G (4F) Repair.

Bay# 10 Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld Joint# 87 located on PCMK NSTL3-3 I/K. Welder is identified as 056364. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2113.

Welding of weld Joint# 87 located on PCMK NSTL3-3 G/K. Welder is identified as 056364. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2333-TC-P4-F.

SMAW Process:

Welding of weld Joint# 152 A/B located on PCMK NSTL3-3 I/K. Welder is identified as 056200. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U5B-1.

Welding of weld Joint# 65 A/B located on PCMK NSTL3-3 I/K. Welder is identified as 040582. ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3212-B-U5B-1.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials

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for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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